

5/24

Split 2 C

DART AEROSPACE LTD		Work Order:	23370
Description: Aft Cap		Part Number:	D2646
Dwg: D2646 Rev. B		Qty:	40
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	(H)	05.06.07	40
2	PG	Issue P/O: <u>2008094</u> Spin as per Dwg D2646 Material release note required	(H)	05.06.07	40
3	RG	Receive and inspect for transit damage Ensure material release note is attached	(C)	05/06/07	40
4	QC6	Inspect dimensions as per Dwg D2646	(Z)	05-06-24	39
5	GA	Drill using DT8026 as per Dwg D2646. Open holes to <u>19/04"</u> +250 per dring	(M)	05-06-24	39
6	GA	Deburr — Counter sink	(M)	05-06-27	39
7	FP	Acid etch and alodine as per QSI 005 4.1	(M)	05/7/4	38
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	(M)	05/01/11	38
9	QC3	Inspect Powder Coat	(R)	06/01/07	36
10	GA	Install Inserts as per Dwg D2646 Pick: Qty Part Number <u>AES10KB16</u> Description <u>Insert</u> Batch <u>M19014</u>	(L)	06/02/28	36
11	QC5	Inspect work to Step 10	(M)	06/03/01	36
12	PK	Identify and Stock	(M)	06/03/01	36
13	AC	Cost / part: _____	(U)	06/03/02	
14	DC	Close W/O Inspect Level 21	(S)	06/03/02	36

Rev	Date	Change	Revised By	Approved
C	98.01.16	Changed Inspection Levels	BW	
D	99.01.04	Added Powder Coat	DM	
E	00.06.22	Removed P/O for powder coat	EC	
F	05.06.07	Reformat	KJ/JLM	

RELEASED
10/05/08

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-24	4	diameter of caps are .020 - .035 under dimension	H	Acceptable	06-03-02 05-06-24	2	H 06-03-02 05-06-24	2 05-06-24

Part No:

PAR #:

Fault Category:

NCR: Yes

DQA:

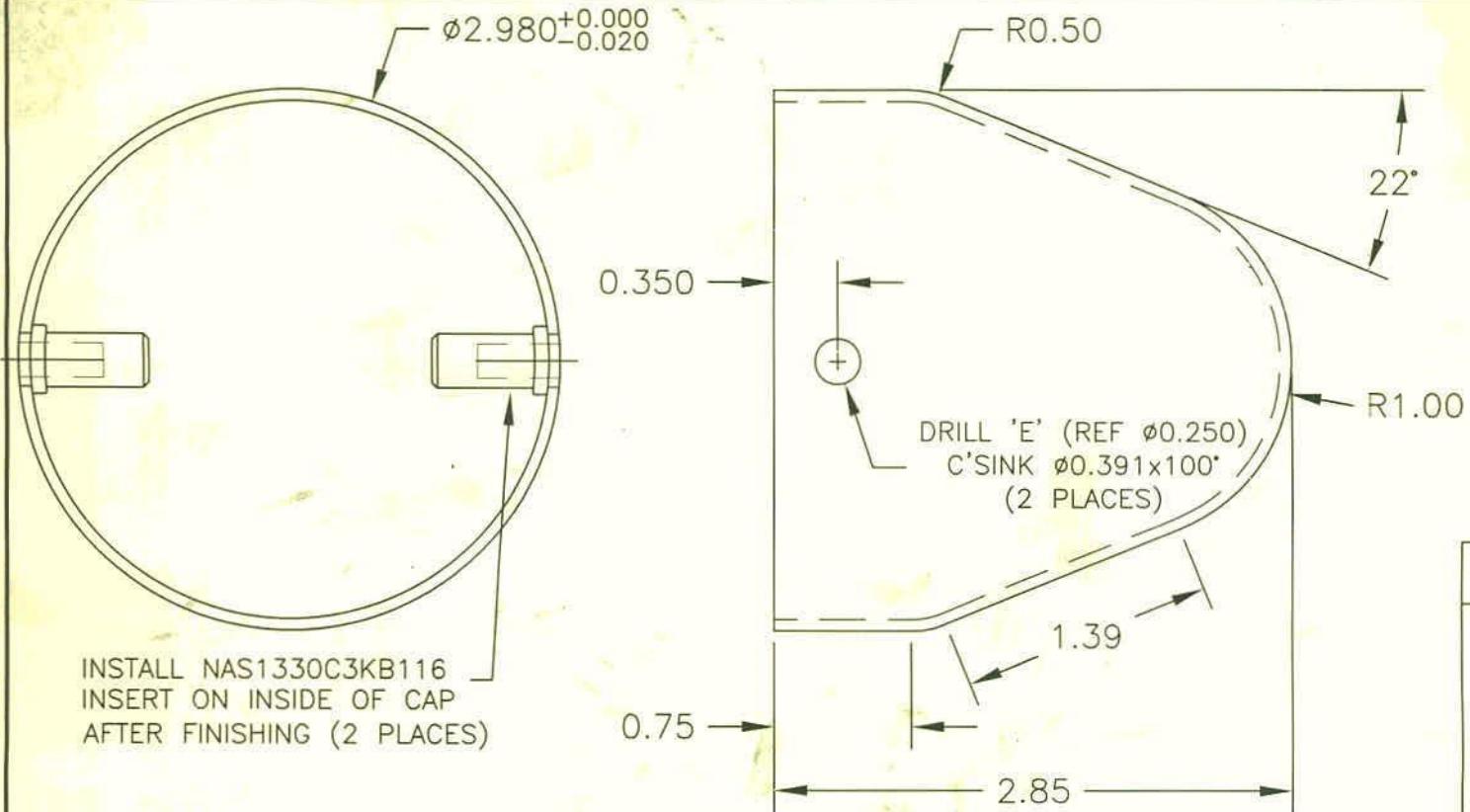
Date: 06/03/24

NOTE: Date & initial all entries

QA: N/C Closed:

Date:

PRELIMINARY ISSUE



D2646 AFT CAP

- 1) MATERIAL: 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 07337
WORK ORDERS
SUBJECT TO
WITHHELD
ENGINEERING
DEPARTMENT
SHOPS

DESIGN DS		DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2646	REV. B	SHEET 1 OF 1
DATE 05.04.01		TITLE AFT CAP	SCALE 1:1	
A	97.03.25	NEW ISSUE		
B	05.04.01	CHANGE TO CLOSED INSERTS		

EUROPEAN MUSEA

THE
MUSEUMS
OF
ART,
HISTORICAL
MONUMENTS,
SCIENCE,
INDUSTRY,
AND
LITERATURE
IN
EUROPE.

BY
WILLIAM
MC
GOWAN,
LONDON,
1851.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 18, 2005
03:08 pm

Work Order No : 0023370 A
 Project Name : D2646
 Project For : WK524
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2646
 Description : Aft Cap
 Manufactured : Yes
 Amount Req'd : 40
 Amount Done : 0
 Start Date : 05-18-05
 Est Finish Date : 06-22-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden	=====	=====	=====		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

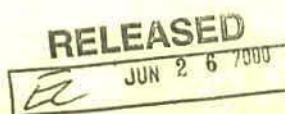
5/24

DART AEROSPACE LTD	Work Order :	23370A
Description: Aft Cap	Part Number:	D2646
Drawing: D2646 Rev. A	Qty:	40

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue Work Order	HJ	05.05.20 40
2	PURCHASING	Issue P/O: 2005094 Spin per Dwg D2646 Material release note required		
3	QC	Inspect Level 6 Ensure material release note is attached	LL	05/05/24 40
4	METAL	Drill as per Dwg D2646 using DT 8026 Open holes to 19/64"		
5	METAL	Deburr		
6		Acid etch and alodine as per QSI 005 4.1		
7	QC	Inspect Level 7		
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3		
9	QC	Inspect Level 3		
10	STORES	Pick: Qty 2 Part Number ALS7-1032-130L or ALS7-1032-130 or ALS4-1032-130	Description Insert	Batch
11	METAL	Install Inserts as per Dwg D2646		
12	QC	Inspect Level 7		
13	STORES	Identify and Stock		
14	EXPEDITING	Close W/O Cost / Part		

Rev	Date	Revised By	Approved
C	98.01.16	BW	
D	99.01.0	DM	
E	00.06.7	EC	

Do not install
inserts - they are
to change!!



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

sm

Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

DATE: May 20 2005

CUSTOMER: Dart Aero

PS INVOICE #: 28954 SUPPLIER #: 2008094

DESCRIPTION OF INSPECTION: Spin Parts .064

NOTES OF INSPECTION: check size.

NOTES OF REJECT: NO

sm

Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
8236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

DATE: May 20 2005

CUSTOMER: Dart Aero

PS INVOICE #: 28954 SUPPLIER #: 2008094

DESCRIPTION OF INSPECTION: Spin Parts .064

NOTES OF INSPECTION: check size

NOTES OF REJECT: NO

1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO COPPER & BRASS SALES INC 22355 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034				SHIP TO COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212				CERT NO 0000598687 DATE 10/26/2004 SKID NO 322296 SKID WGT 9,760 PAGE 1 OF 1			
ORDER NO	LB4176	PG NO	C99792					MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED			
ITEM NO	1	PART NO	050393-8								
ALLOY	1100	TEMPER	O	FORM	COIL						
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000						
LOT: 238066 COIL: B01 DROP: 440525											
INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI		
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02		
HEAD ULTIMATE STRENGTH 12.2 KSI TAIL ULTIMATE STRENGTH 12.6 KSI HEAD YIELD STRENGTH (OFFSET = .2t) 4.9 KSI TAIL YIELD STRENGTH (OFFSET = .2t) 5.6 KSI HEAD ELONGATION (G.L. = 2 IN) 35.5 % TAIL ELONGATION (G.L. = 2 IN) 33.5 %											
CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04 MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a											
MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF: ASME SB209 1100 O, AMS 4001H 1100 O, ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O											
CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL ** END OF CERTIFICATION **											
This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.						Authorized By: JEFF FREDDY, LAB SUPERVISOR					

*AAC Henry C. Sieg
CIO Sale G. CPS*

